: FUEL PURGE CANISTER INSTALLATION

Qty:

: D412706011

: N/A

: N/A

: N/A

: 7/8/2008

Each

1 Um:

JUD

Date:

Tuesday, 7/1/2008 10:48:39 AM

: 38439

User:

Kim Johnston

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Type

Job Number : 40167 : 10856

Estimate Number

P.O. Number

This Issue

: 7/1/2008 : NC Prsht Rev.

First Issue : //

Previous Run

Written By

Checked & Approved By

Comment

04.12.03 : Est Rev:E

AN924-6D KJ/JLM

: LARGE FAB ASSY

Est Rev:F 08-05-14 revise comment in seq.17 /24 DD verified

Remove AN6289-6D; Change Qty of

by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: DOCUMENT CONTROL

1.0 DC

2.0



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-706-011CHG001



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

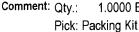
Pick Packing Kit

3.0 D20014 Valve Assembly (1/4")



1.0000 Each(s)/Unit Total:

1.0000 Each(s)



Qty Part Number

Description

1 D2001-4

Valve Assembly

Batch

4.0

D3262041

Canister Assembly



Comment: Qty.:

Total:

1.0000 Each(s)

1.0000 Each(s)/Unit Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3262-041

Canister Assembly

D	aı	t	A	er	O	sp	a	C	е	L	td

W/O:		WORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No DO	Δ.	Date:	

QA: N/C Closed: ____ Date: _

NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B		Verification	Annrovol	Approval QC Inspector					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng						

Tuesday, 7/1/2008 10:48:39 AM Date: Kim Johnston Üser: 4 **Process Sheet** Drawing Name: FUEL PURGE CANISTER INSTALLATION Customer: CU-DAR001 Dart Helicopters Services Part Number: D412706011 Job Number: 40167 Job Number: Description: Seq. #: Machine Or Operation: Bracket D32641 By22.58 14 /08/1/9 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Packing Kit Qty Part Number Description 08/07/02 (xc 2 D3264-1 **Bracket** D329710098 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit Batch Qtv Part Number Description 1 D3297-1-0098 Hose Assembly D329730085 7.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit Description Qty Part Number 1 D3297-3-0085 Hose Assembly_ D329730210 8.0 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Packing Kit Description Batch **Qty Part Number** D3297-3-0210 Hose Assembly 9.0 D3298001 Comment: Qty... 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Packing Kit Qty Part Number Description 1 D3298-001 Tube Assembly Tube Assembly D3298003 10.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description D3298-003 Tube Assembly

W/O:	-	WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:	
			QA:	N/C Close	d:	_ Date: _	· · · · · · · · · · · · · · · · · · ·

		WORK ORDER NON-CONFORMANCE (NCR)										
	Description of NC		Corrective Action Section B		Varification	Annroval	Approval QC Inspector					
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng						
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Chief Eng					

Tuesday, 7/1/2008 10:48:39 AM Date: Kim Johnston Üser: 1 **Process Sheet** Drawing Name: FUEL PURGE CANISTER INSTALLATION Customer: CU-DAR001 Dart Helicopters Services Part Number: D412706011 Job Number: 40167 Job Number: Seq. #: Description: Machine Or Operation: Tube Assembly 11.0 D3298005 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description 38450 Tube Assembly 1 D3298-005 D3298007 Tube Assembly 12 0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description Batch 08/07/02 1 D3298-007 Fitting D3298009 Tube Assembly 13.0 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total : Pick: Packing Kit Batch **Qty Part Number** Description 39410 D3298-009 Tube Assembly_ D32991 14.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit **Qty Part Number** Batch Description Fitting 1 D3299-1 D32993 15.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit **Qty Part Number** Batch Description 1 D3299-3 Fitting D32995 16.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit D3299-5

Dart Ae	rospace	e Ltd							
W/O:			WC	ORK ORDER CHANGES					
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		Description of NC		Corrective Action Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti		Chief Eng	QC Inspector
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Tuesday, 7/1/2008 10:48:39 AM Date: Kim Johnston Üser: ∙ **Process Sheet** Drawing Name: FUEL PURGE CANISTER INSTALLATION Customer: CU-DAR001 Dart Helicopters Services Part Number: D412706011 Job Number: 40167 Job Number: Seq. #: Machine Or Operation: Description: Placard 17.0 D33011 Comment: Qty.: 1.0000 Each(s) Total: 1.0000 Each(s)/Unit Pick: Packing Kit **Qty Part Number** 1 D3301-1 D33013 18.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1,0000 Each(s) Pick: Packing Kit **Qty Part Number** Description Batch 23305 Placard_ 1 D3301-3 Doubler D33021 19.0 Comment: Qty.: Total: 1.0000 Each(s) 1.0000 Each(s)/Unit Pick: Packing Kit **Qty Part Number** Description Doubler D3302-1 1 20.0 D33023 Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Pick: Packing Kit **Qty Part Number** Description 1 D3302-3 Doubler 21.0 D33291 -€omment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Packing Kit Qty Part Number Description 2 D3329-1 Bushing 22.0 AN35A Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Packing Kit Batch 1601 88 **Qty Part Number** Description 4 AN3-5A Bolt

Dart Ae	rospace	e Ltd							
W/O:			W	ORK ORDER CHANGES	3				
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:				_ Date: _ _ Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section I Action Description Chief Eng	Sign & Date	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
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Tuesday, 7/1/2008 10:48:39 AM Date: Kim Johnston Üser: ∙ **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: FUEL PURGE CANISTER INSTALLATION Part Number: D412706011 Job Number: 40167 Job Number: Seq. #: Description: **Machine Or Operation:** Plug 23.0 AN8146D Comment: Qty.: 1.0000 Each(s) 1.0000 Each(s)/Unit Total : Pick: Packing Kit Qty Part Number Description 1 AN814-6D Plug AN8156D Union-M-Flare 24.0 Comment: Qty.: Total: 3.0000 Each(s) 3.0000 Each(s)/Unit Pick: Packing Kit **Qty Part Number** Description 3 AN8156d Plug AN8326D 25.0 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Packing Kit Description Batch **Qty Part Number** M17654 1 AN832-6D Union ____ 26.0 AN8336D Elbow, Bulkhead-M-Flare Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Packing Kit **Qty Part Number** Description 2 AN833-6D Union AN9246D 27.0 Comment: Qty.: 5.0000 Each(s) 5.0000 Each(s)/Unit Total: Pick: Packing Kit **Qty Part Number** Description 5 AN924-6D Nut Tee 28.0 AN9386D Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit M17654 **Qty Part Number** Description Batch

Page 5

Dart Ae	rospace	e Ltd							
W/O:	1		W	ORK ORDER CHANGES	3				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	No DQA	\:	Date:	
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		Description of NC		Corrective Action Section I	3	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

Date: User:	Kim Johnston	1VIA 5C.04.UI	Process Sheet	
Custo	mer: CU-DAR001	Dart Helicopters Services		e: FUEL PURGE CANISTER INSTALLATION
Joh Num	ıber: 40167		Part Number:	r: D412706011
Job Number:				
Seq. #:		r Operation:	Des	scription :
	1 AN9	38-6D Tee		
29.0	AN960JD10		Washer	1111111111111
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30.0	AN960JD10L		Washer	J 3 91 10 71 00 CE
Co	•	4.0000 Each(s)/Unit Total :	4.0000 Each(s)	111111111111111111111111111111111111111
7	Pick: Pad Qty Part		Batch	12.
	4 AN96		M64885	8) 08/04/02 EC
31.0	MS21042L3		Nut	
Co	mment: Qty.: Pick: Pad	4.0000 Each(s)/Unit Total :	4.0000 Each(s)	1
U	Qty Part	Number Description	Batch Mo 7/465	· K whole c
32.0	4 MS2 MS21919WD	1042L3 Nut (or -3)	Clamp	10 3 00 10 -1 02 (xc
Co	mment: Qty.;	2.0000 Each(s)/Unit Total :	2.0000 Each(s)	LINDIN DATE HELD
O	Pick: Pad Qty Part		Batch	10
	-	1919WDG9 Clamp	Motors	8) 0/107/02/VI
33.0	MS2192042		CLAMP(per MIL-DTL-8783C)	
	.			
Co	mment: Qty.: :: Pick: Pac	2.0000 Each(s)/Unit Total :	2.0000 Each(s)	
U	Qty Part	Number Description	Batch	
•	2 MS2	1920-42 Clamp	ationed.	X 08/07/02 (xc
				70-71

Dart Ae	rospace	Ltd							
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		Description of NC		Corrective Action Section	on B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	ion C	Chief Eng	QC Inspector
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11011.			•		, ,			
		Description of NC	Description of NC Corrective Action Section B				Approval	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

Tuesday, 7/1/2008 10:48:40 AM Date: Kim Johnston Üser: • **Process Sheet** Drawing Name: FUEL PURGE CANISTER INSTALLATION Customer: CU-DAR001 Dart Helicopters Services Part Number: D412706011 Job Number: 40167 Job Number: Description: Seq. #: Machine Or Operation: Packing 34.0 MS287786 10.0000 Each(s) Comment: Qty.: 10.0000 Each(s)/Unit Total: Pick: Packing Kit Qty Part Number Description Batch 10 MS28778-6 O-Ring GROMMET MS3548911 35.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Packing Kit Description **Qty Part Number** Batch 1 MS35489-11 Grommet INSPECT 100% KITS FOR COMPLETENESS 36.0 QC4 08/07 Comment: INSPECT KITS FOR COMPLETENESS PACKAGING RESOURCE #1 37.0 PACKAGING ' Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-706-011 PPP Rev: FINAL INSPECTION/W/O RELEASE 38.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart /	Aeros	pace	Ltd
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W/O:		WORK ORDER CHAN	IGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:		
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE STEP	Description of NC		Corrective Action Section B		Verification	Ammanual	Ammount	
	STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
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